Work Order ID 71010 Page 1 Tuesday, June 21, 2011 9:01:37 AM Item ID: D3294-1 Accept Setup Start **Revision ID:** Item Name: Bracket Stop **Start Date:** 6/20/2011 Start Qty: 8.00 **Cust Item ID: Required Date: 6/20/2011** Req'd Qty: 8.00 **Customer:** Reference: Run Start Approvals: **Tooling: Process Plan:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Stamp Number Draw Nbr **Revision Nbr** D3294 Rev C 100 0.00 B11-6-21 Waterjet 0.00 Memo FLOW CNC Wateriet 1-Cut as per Dwg D3294 CUt File D3294-3 20 . HECC Dwg Rev: Prog Rev: C *grain direction on a 45 deg as per dwg**

110

Quality Control

QC2- Inspect parts off machine FAI/FAIB

2-Deburr if necessary

0.00

Memo

0.00

B11-6-21

	Dart	Aeros	pace	Ltd
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W/O:			WO	RK ORDER CHANG	ES		· · · · · · · · · · · · · · · · · · ·		<u>'</u>
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		Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE	STEP	STEP Description of NC - Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Secti		Chief Eng	QC Inspector
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Work	Order	· ID	71010
Tuesday	June 21	2011	9.01.37

Quality Control



Page 2

Tuesday, June 2	1, 2011 9:01	:37 AM			FIEI (14(1 0E11 16E1							1 age 2
Item ID: Revision ID: Item Name:	D3294-1 Bracket) (MA) (A) (MA)	Accept					Setup	Start Stop	1 19 8 8 1	
Start Date: Required Date: Reference:	6/20/2011 6/20/2011	Start Qty: 8.00 Req'd Qty: 8.00			Cust Item I Customer:	D:						
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		ite:			Run	Start Stop		
Sequence ID/ Work Center II 120 QC QC Quality Control)	Operation Description QC8- Inspect parts - seco	nd check	Set Up/ Run Hours 0.00 0.00 1/ / 64/7	Tool ID	Tool #	Plan Code	Accep Qty	Qty		Reject Number	Insp. Stamp
130 Brake NC Brake NC		Memo 1-Deburr if n 2-Bend as pe (Ensure angle	r Dwg D3294	0.00 0.00 SA	1166/27		E	3		· · · · · · · · · · · · · · · · · · ·	æ	
140 QC		QC5- Inspect part comple	eteness to step on W/O	0.00 كياره	127			(+E	} —			

Dart Aerospace Lt	:d
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W/O:			W	ORK ORDER CHANG	GES				·
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Part No	•	PAR #:	Fault Cate	gory:	NCR: Ye	s No DQ	A:	Date: _	
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NCR:		,	WORK ORD	ER NON-CONFORM	ANCE (NO	R)			
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Work	Order	ID	71010
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Tuesday, June 21, 2011 9:01:37 AM



Page 3

Item ID:

D3294-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Start Date:

Required Date: 6/20/2011

6/20/2011

Start Oty: 8.00

Req'd Qty: 8.00

Operation

Description



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____

Chemical Conversion Coat per QSI005 4.1

Date:

Tooling:

Date: Date:

Run

Start Stop

Stop



QC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Tool ID

Tool # Plan

Code

Accept Qty

Reject Reject Qty Number

Insp. Stamp

Sequence ID/ Work Center ID 150

HandFinish

Memo

0.00

0.00

Hand Finishing

160

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

170

Small Fab

Memo

0.00

0.00

Small Fab

1-Install D3294-5 doubler to D3294-3 bracket with rivets as per dwg. D3294

W/O:		With the State of	WC	RK ORDER CHAN	GES				· ·
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Work Ord Tuesday, June 2								-		-, 41	Page 4
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Reference: Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):	D	ate:		R	un Star Stop		
Sequence ID/ Work Center II 180 QC Quality Control	D	Operation Description QC5- Inspect part comple Memo	eteness to step on W/O	Set Up/ Run Hours 0.00 0.00	Tool ID			accept Oty	Reject Qty	Reject Number	Insp. Stamp
Powdercoat Powder Coating	6128	Black Sandtex(Ref: 4.3.5. Memo Start Time: Oven Tempe Finish Time:	2 = 30' rature: _ 320	0.00 Ol ^{-2.00}			5	BXL	8/1	ML	11/06/27
200 QC Quality Control		QC3- Inspect Part Finish Memo	3 /00	0.00		·		8	\$	H	ul06/26

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Work Order ID 71010

Tuesday, June 21, 2011 9:01:38 AM



Page 5

Item ID:

D3294-1

Accept

Setup Start

Stop

Revision ID:

Item Name: Bracket

Required Date: 6/20/2011

6/20/2011

Start Qty: 8.00

Req'd Qty: 8.00



Cust Item ID: Customer:

Reference:

Start Date:

Approvals:	Process Plan:	Date:	Tooling:	D:	ate:		Ru				
	QC:	Date:	SPC (Y/N):	Date:			Stop				
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210 Packaging	Identify as per dwg o	& Stock Location:	0.00				. (/		, 2		
Packaging											

220

QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

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W/O:			WO	RK ORDER CHANG	GES				· · · · · · · · · · · · · · · · · · ·
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Picklist Print

Tuesday, June 21, 2011 9:01:44 AM

Work Order ID: 71010

Parent Item:

D3294-1

Parent Item Name:

Bracket



Start Date: 6/20/2011

Required Date: 6/20/2011

Page 1

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP □A□04.08.24□New issue□KJ/JLM□

IPP Rev:B Now On Waterjet 07-03-26 JLM

IPP Rev:C 08-07-16 Redesign part DD verified by:EC IPP Rev:D 08-10-06 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased	No	-		100	sf	110.1000	1.8	15.15789		2.6	***************************************
2024-T3 .080 sheet									1110111001		B11-6-	H	
				Location		Loc	<u>Qty</u>	Loc Code					
				MAT022		1	10.1						
					105411		6		_		-	(2)	
					109424		4		_		-	(C)	
	<i>H</i>				110347		0.5				-		
					110908		3		_		_		
					112331		3				-		
					113796		7				_		
					114025		17.2				-	•	
					116604		5.8		-	(770)	_		
2004 6					117392		63.6		<u>_(</u>	(734)	-		
D3294-5 		Manufactured	No			170	Each	25.0000		§344	06/2	⁄ }	
				Location		Loc	<u>Otv</u>	Loc Code			,		
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Picklist Print

Tuesday, June 21, 2011 9:01:44 AM

Page 2

Work Order ID: 71010

Parent Item:

D3294-1

Parent Item Name: Bracket



Start Date: 6/20/2011

Required Date: 6/20/2011

Start Qty: 8.00

Required Qty: 8.00

MS20470AD4-5

Purchased

No

170

Each 790.0000 15

Rivet, Universal Head

Location

ST319

116893

Loc Qty 790

790

Loc Code

W/O:		WORK ORDER CHANGES												
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71010

DART AEROSPACE LTD	Work Order:	7100
Description: Bracket Assembly	Part Number:	D3294-1
Inspection Dwg: D3294 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

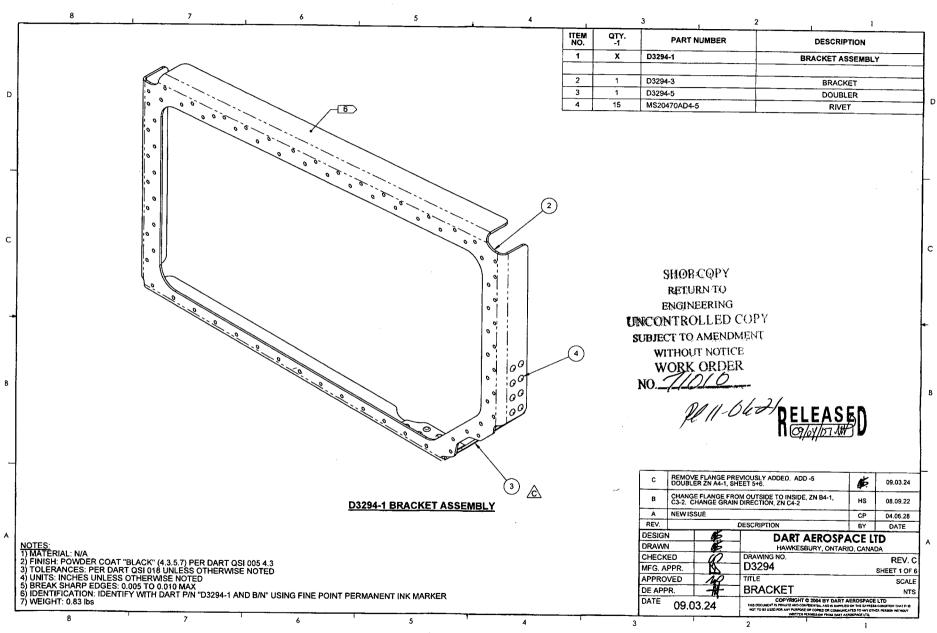
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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Ø0.141	+0.005/-0.001	1143	7		V	
6.708	+/-0.010	6,714	S		V	
1.118	+/-0.010	1.118	×		V	
5.590	+/-0.010	5.594	7		v	
1.118	+/-0.010	1.118	2		V	
13.563	+/-0.010	13,563	8		T BOI	
1.043	+/-0.010	1.643	8		V	
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0.325	+/-0.010	,373	¥		v	, t.,
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1.000	+/-0.010	1.008	8		/	
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16.13	+/-0.030	16.13	4		7	
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8.37	+/-0.030	8.371	k		P	
20.05	+/-0.030	₽0.06	7		7	
12.98	+/-0.030	७२.६१	5		T	· · · · · · · · · · · · · · · · · · ·
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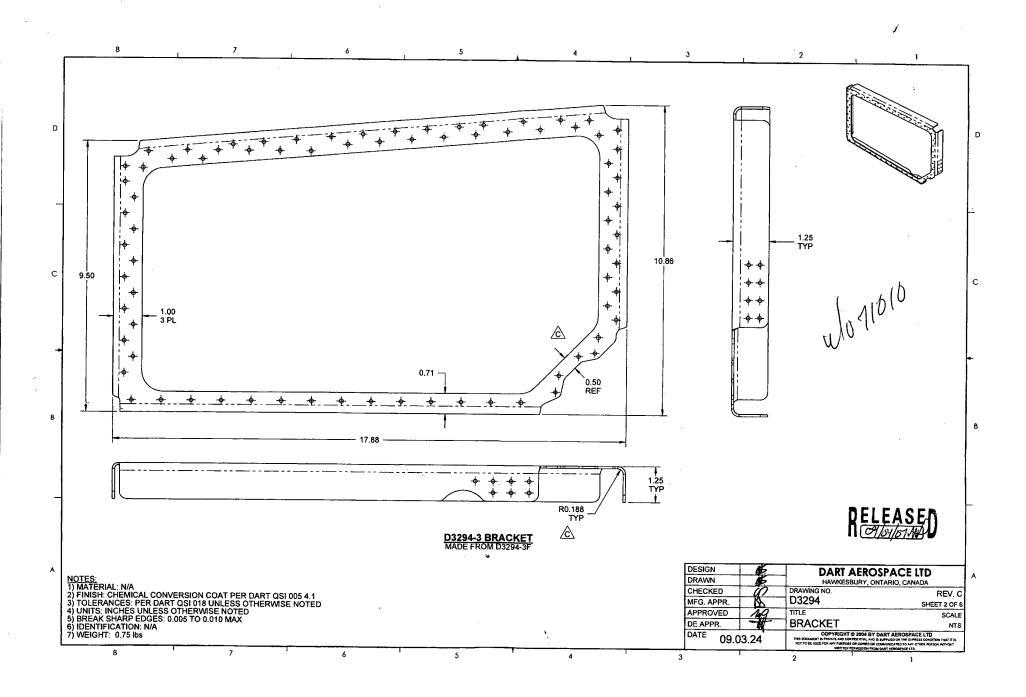
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Date: 11-6-21	Date: 11/06/72	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.08.24	New Issue	KJ/JLM	
В	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	•
С	08.11.27	Dimensions updated per Dwg Rev B	KJ/EC	
D	09.07.29	Dimension 2.100 was 2.072	KJ . A	
E	09.09.14	Dimensions updated per Dwg Rev C	KJ del-	M

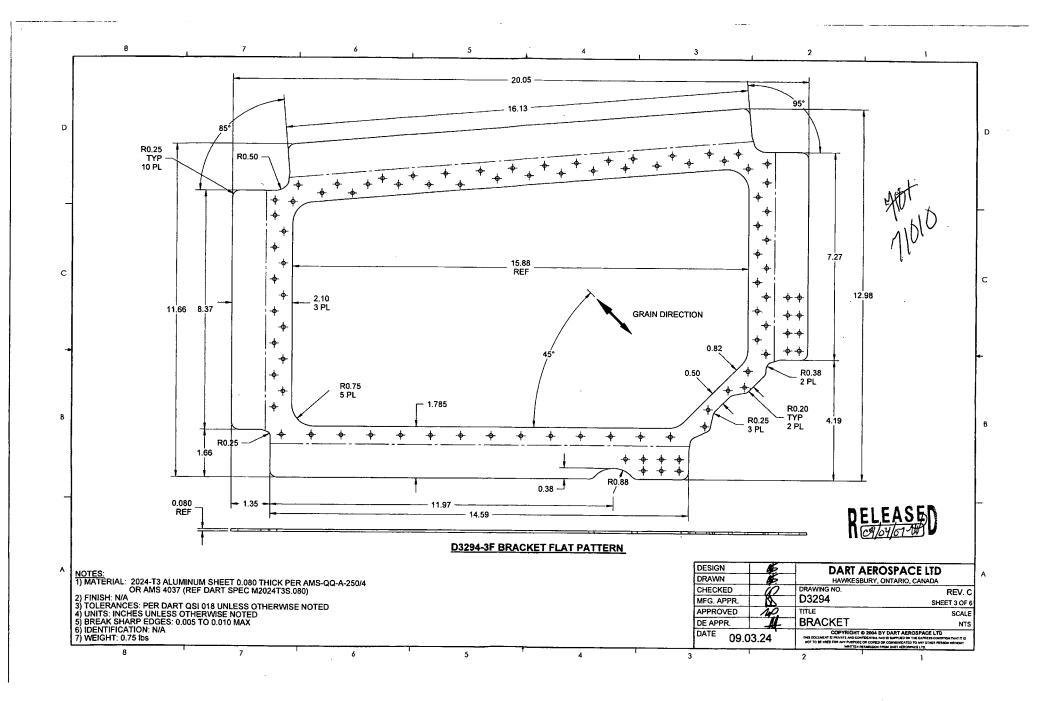
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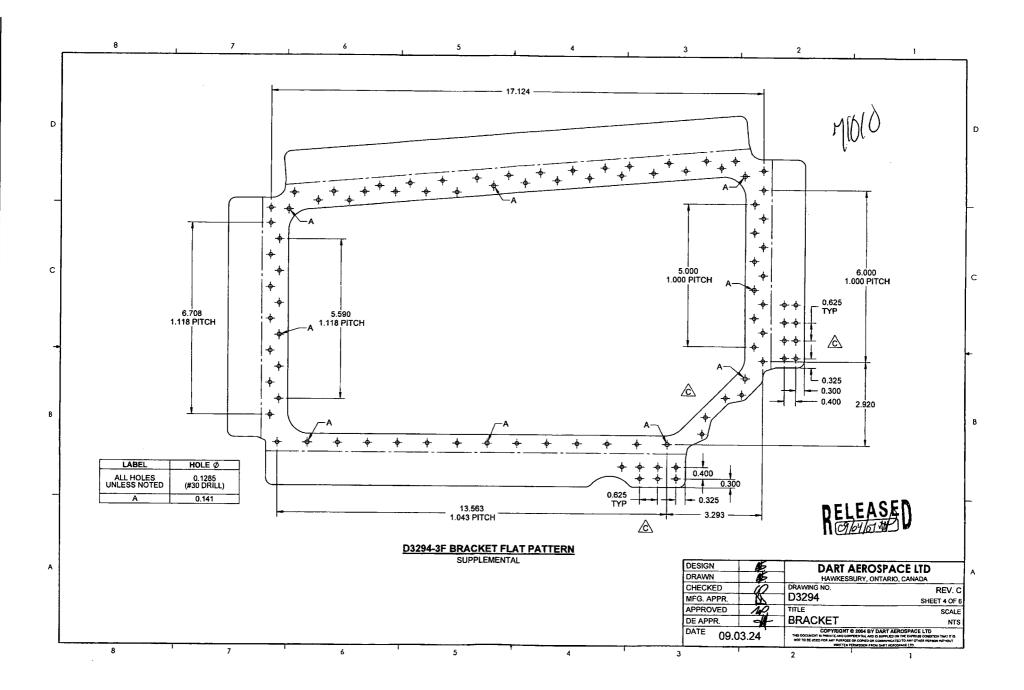
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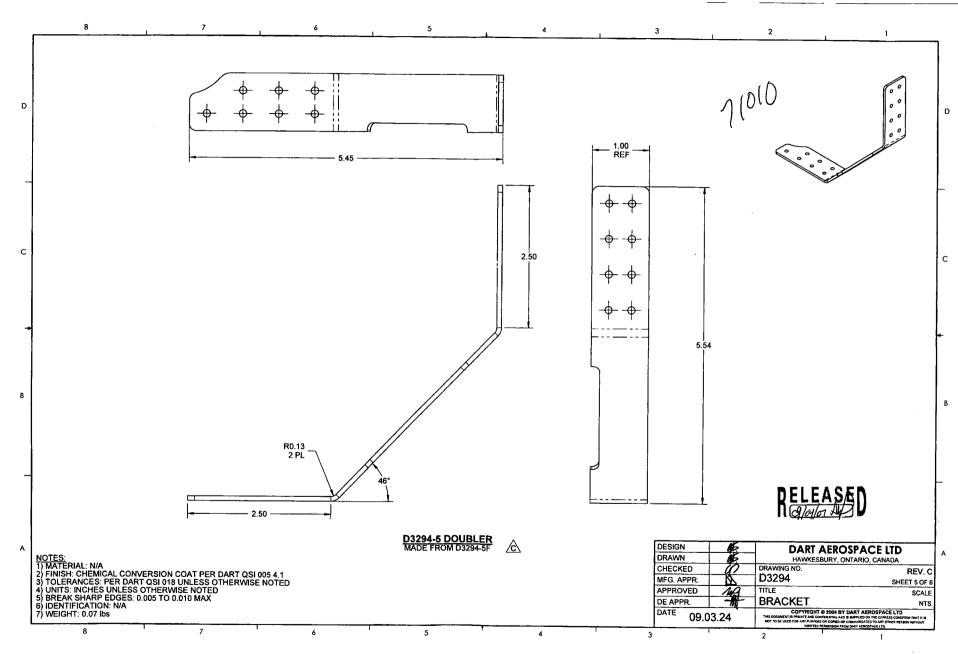
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R0.25 0.625 TYP Ø0.129 - 0.30 15 PL - 0.300 R0.88 GRAIN DIRECTION 0.400 1.00 R0.13 2 PL 0.15 0.30 - 0.53 R0.13 2.50 - 4 PL TYP 9.21 0.080 REF **D3294-5F DOUBLER FLAT PATTERN** NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/4
OR AMS 4037 (REF DART SPEC M2024T3S.080)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.07 lbs DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. C D3294 MFG. APPR. SHEET 6 OF 6 APPROVED TITLE SCALE BRACKET DE APPR. NTS

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DATE

09.03.24

Dart Aerospace L	∟td
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